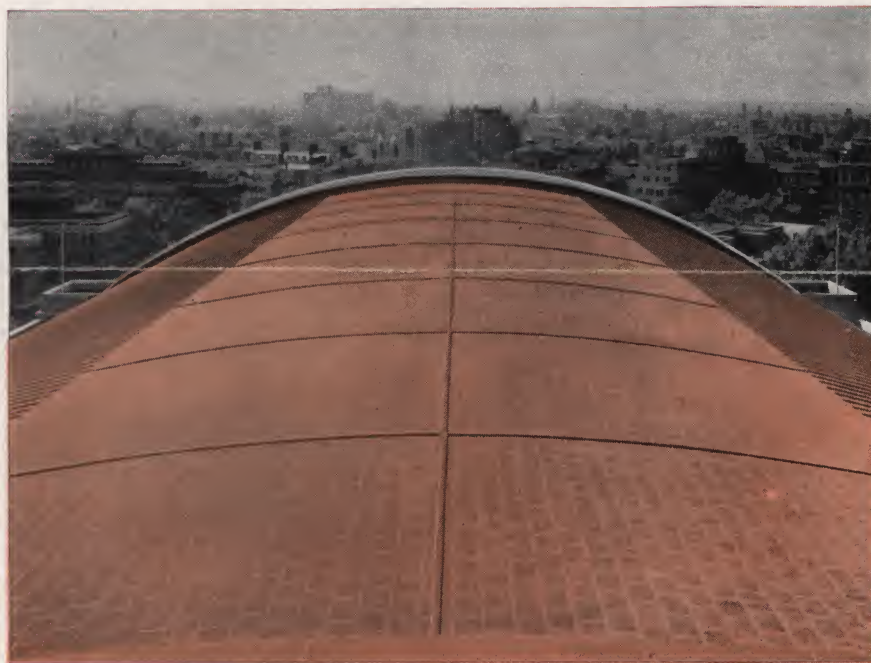


9/7/54

**ANACONDA COPPER**  
FOR  
ROOFING AND GENERAL SHEET METAL WORK

**No. 1** This is the first of a series of booklets suggesting design and installation methods for various forms of sheet copper construction.

# FLAT LOCK SOLDERED SEAM COPPER ROOFING



**THE AMERICAN BRASS COMPANY**  
GENERAL OFFICES: WATERBURY 20, CONNECTICUT



# FLAT LOCK SOLDERED SEAM

## COPPER ROOFING

THE general principles and installation procedure applying to the flat seam type of copper roofing are well understood by the experienced sheet metal craftsman. The following data and construction details, however, may be helpful in obtaining a long-lasting, trouble-free installation.

### TEMPER

Use copper cold rolled to "cornice" temper.

### SIZE AND WEIGHT

20 oz. copper is recommended for squares 16" x 18". Suggested gage weights for other sizes are given in the table at right.

### ALLOWANCE FOR EXPANSION AND CONTRACTION

For roofs 50' square and larger, it is good practice to install expansion battens, dividing the surface into smaller areas—see plate II, Figure 5 and crown of roof on cover photo.

Smooth building paper laid between the copper and the asphalt saturated roofing felt provides a better surface for the movement of the metal caused by temperature changes.

### CLEATS

Should be of copper and spaced not more than 12" apart.

### FASTENINGS

Use flat head copper nails of a size and style best suited for the type of roof deck construction. (Nails should not protrude through the under surface of the decking.) Screws, when required, should be brass or bronze.

### SERVICE

Our Engineering Department will gladly cooperate in the solution of individual problems involving the use of Anaconda Building Products.

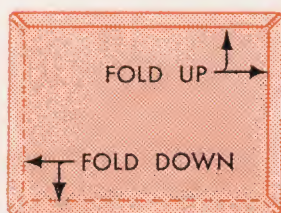
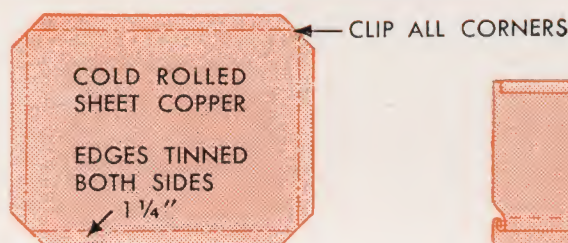
### NOTICE

The statements and data contained in this publication are based on extensive investigation and practical experience and represent the best information available at time of printing—October 1949.

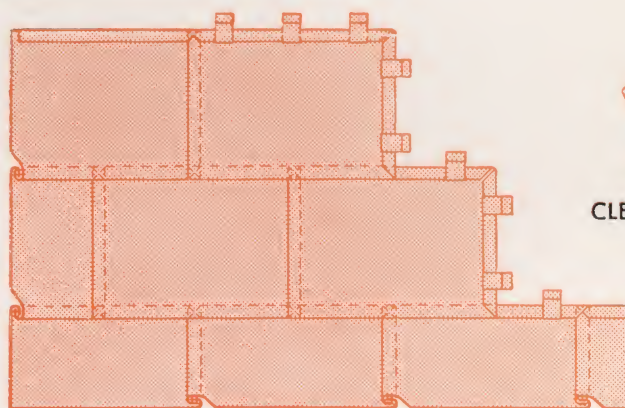
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### ROOFING SQUARES FOR FLAT LOCK SEAM COPPER ROOFING

SIZE OF SQUARES	GAGE WEIGHT
12" x 15"	16 oz.
14" x 16"	18 oz.
16" x 18"	20 oz.
18" x 24"	24 oz.
24" x 36"	32 oz.
30" x 60"	40 oz.



FORMED ROOFING SQUARE



CLEAT DETAIL

APPLICATION OF ROOFING SQUARES



## BORDER DETAILS

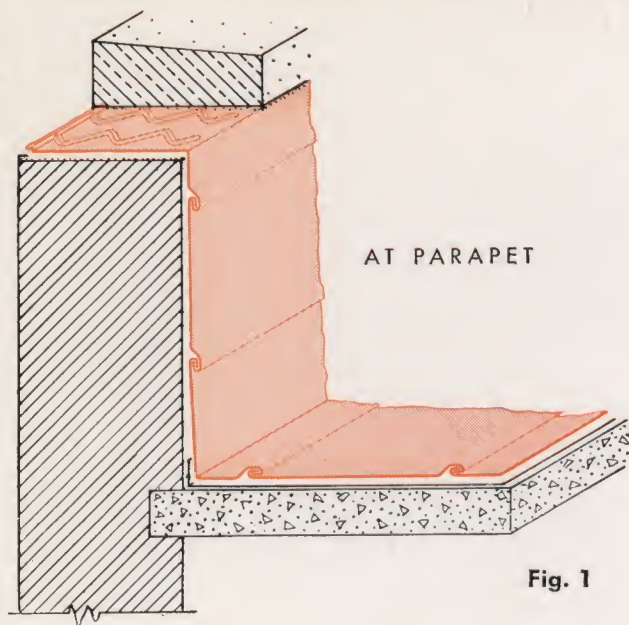


Fig. 1

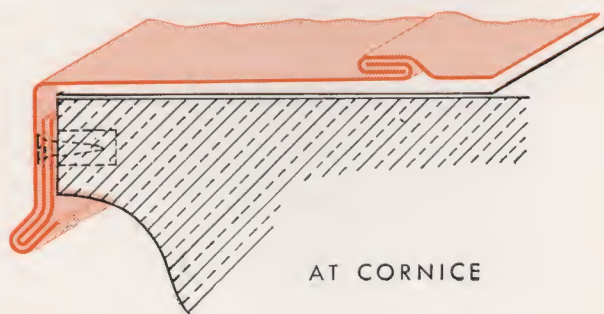


Fig. 2

## EXPANSION BATTEN CONSTRUCTION

Fig. 3

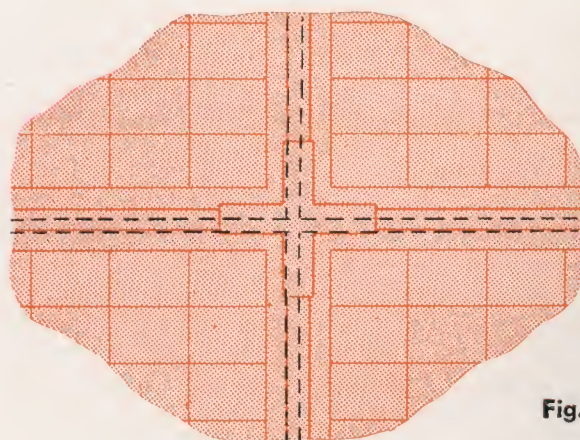


Fig. 5

Fig. 4

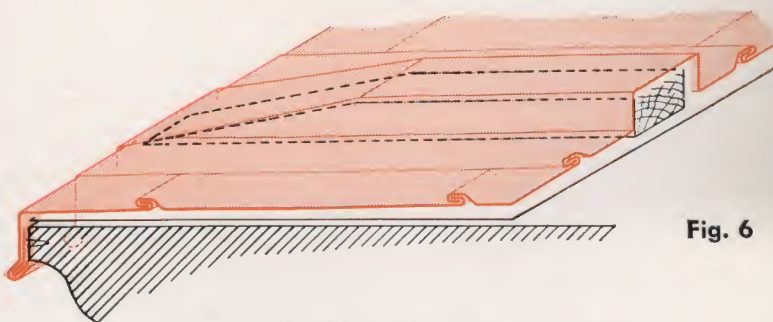
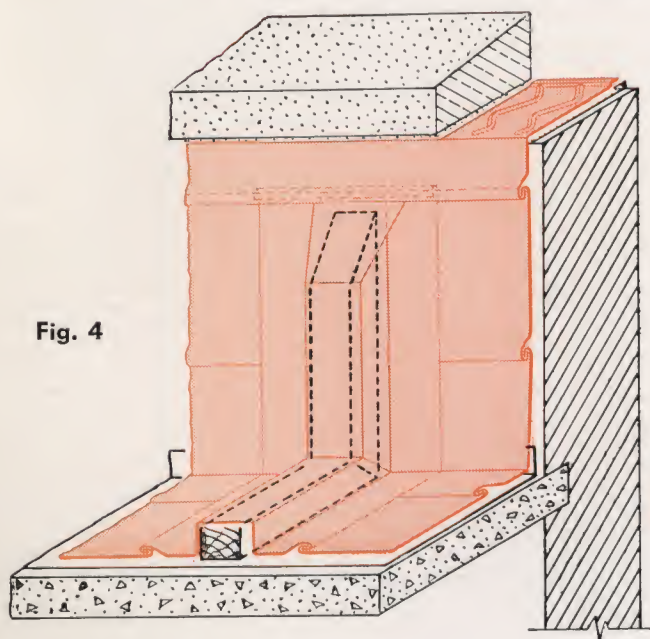


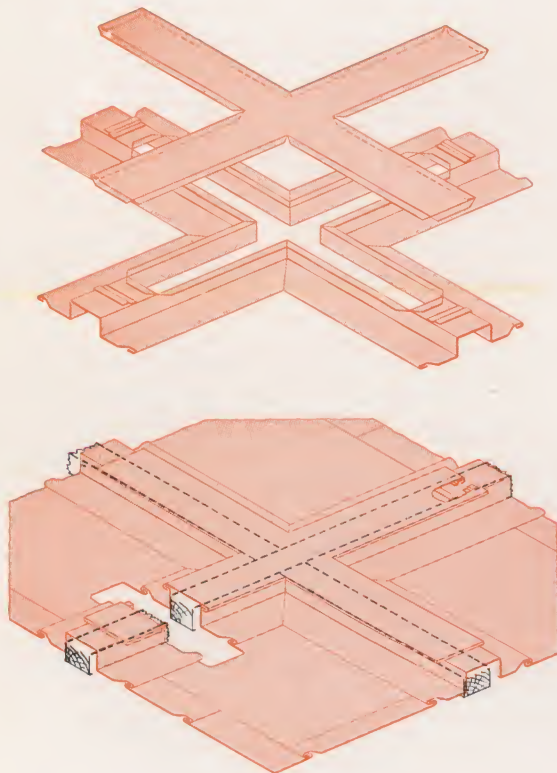
Fig. 6



## CONSTRUCTION AT INTERSECTIONS OF EXPANSION BATTENS

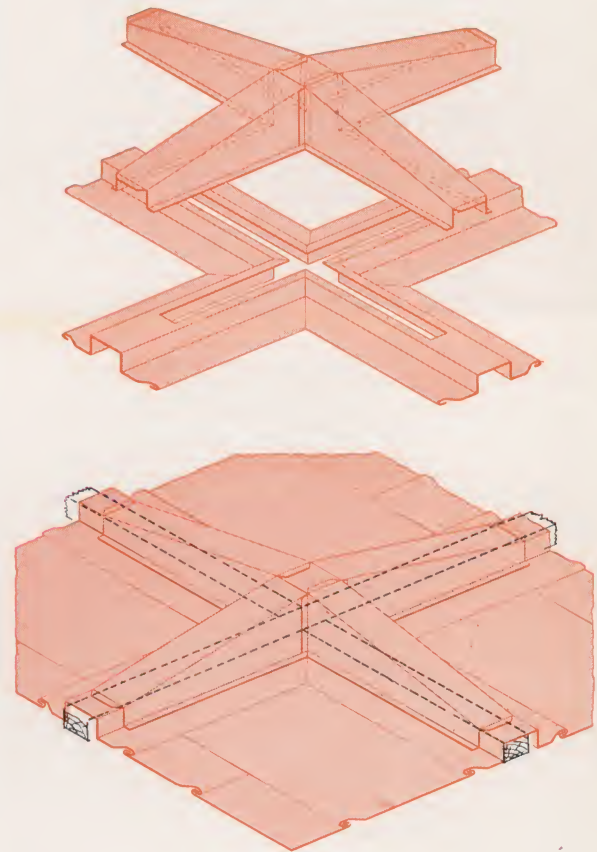
Expansion battens are installed to provide the necessary freedom for movement in the copper roofing caused by temperature changes. Construction at the intersection or crossing of battens must be designed to yield without overstressing the metal.

*Cover piece raised to show construction and cutaway section at top of battens. Intersecting battens in upper drawing are not shown.*



**Fig. 7 . .** Shows an intersection with a free-moving, weathertight cover over the expansible cutaway portion at the top of the battens. This type is suitable for the crown or ridge of a low pitch roof.

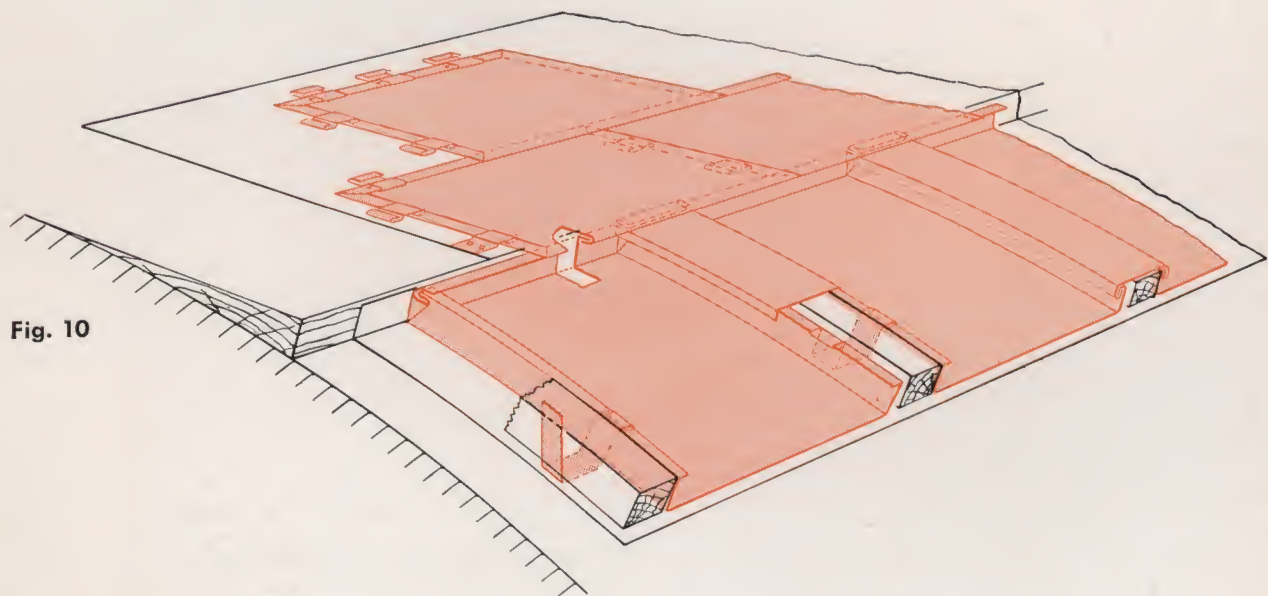
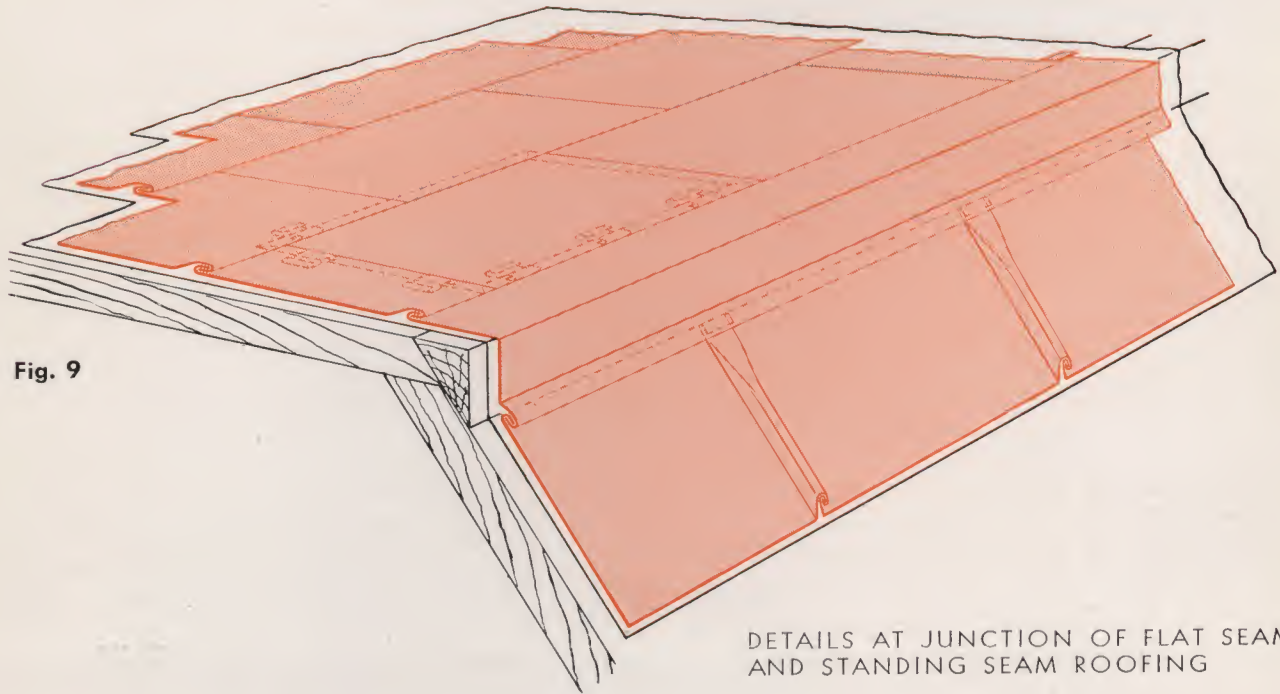
*Cover piece raised to show construction and cutaway section at top of battens. Intersecting battens in upper drawing are not shown.*



**Fig. 8 . .** Shows an intersection with a raised cap soldered to the expansible cutaway portion. This type is designed for flat roofs or where the water level may reach the top of the battens.

## FLAT SEAM ROOFING JOINED TO OTHER TYPES OF COPPER ROOFING

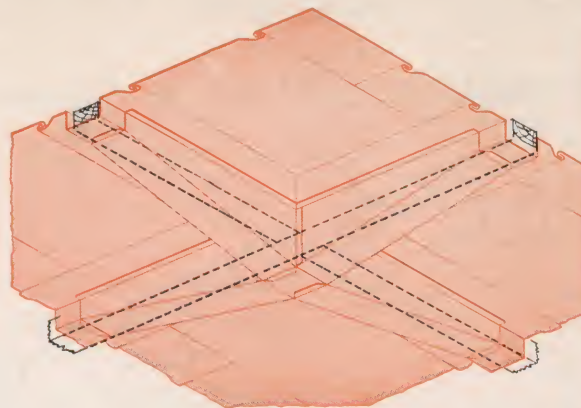
Roof design often requires the use of both flat seam roofing and batten or standing seam construction. The drawings below suggest methods of installation at junction.



DETAILS AT JUNCTION OF FLAT SEAM AND BATTEN SEAM ROOFING (See cover photo)



Mr. M. M. Maxwell, Arch.  
Sport & Maxwell  
410 Vincent Building  
New Orleans, Louisiana



design and  
construction detail

## Flat Seam COPPER ROOFING

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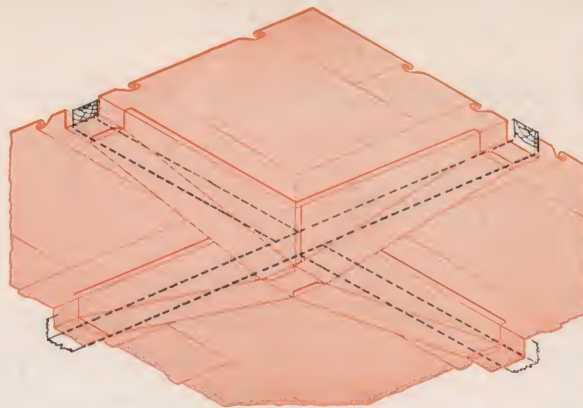


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